

# Duro-M - 4-Jaws, drilling and turning jaws, Camlock (ISO 702-2/DIN 55029)

## APPLICATION

Conventional clamping horizontal and vertical turning machines, as well as milling machines, rotary tables and dividing attachments. Predominantly for use in single or small batch production or in repair shops. Clamping of rotationally symmetrical parts for turning and milling.

## TYPE

The Duro-M is a manually geared scroll chuck with through-hole, drilling and turning jaws with cylindrical mount. It is mainly used on conventional turning machines for machining turned parts.

## CUSTOMER BENEFITS

- High concentricity up to 0.02 mm
- Jaws with gunmetal finish
- Minimal interference contour
- Optimum force transmission
- Drip edge for coolant

## TECHNICAL FEATURES

- Chuck body (and all other components) made of steel
- Centric clamping via scroll ring
- Scroll plate drop forged and highly tempered, the thread flanks are ground on both sides.
- Jaws in chuck ground out for concentricity
- Zero drive determined in the factory as precision drive
- The maximum permissible speed has been fixed so that 1/3 of the gripping force is still available as residual gripping force if the maximum gripping is applied and the chuck is fitted with its heaviest jaws. The jaws may not project beyond the outside diameter of the chuck. The chuck must be in perfect condition. The specification DIN 6386 Part 1 shall be observed.
- Clamping force to DIN 6350: The gripping force is the sum total of all jaw forces acting radially on the stationary workpiece. The specified gripping forces are approximate values. They apply to chucks in a perfect condition which have been lubricated with RöhM F80 grease.
- Scope of supply: chuck, operating key, jaws. The DURO-M chucks are available as 2-, 3- and 4-jaw chucks up to and including Ø315mm size with the machined scallops. All 4-jaw chucks with front mounting have no scallops. All 6-jaw chucks also have no scallops.



A09 830

Size	125	160	160	200	200	250	250	315	315	315	400	400	500	500	630	630
Short taper	4	4	5	5	6	6	8	6	8	11	8	11	11	15	11	15
A [mm] outer diameter	125	160	160	200	200	250	250	315	315	315	400	400	500	500	630	630
B Spindle mount	63,5	63,5	82,5	82,5	106,4	106,4	139,7	106,4	139,7	196,9	139,7	196,6	196,9	285,8	196,9	285,8
D [mm] Chuck height	69	66	66	74,5	74,5	83	83	96	96	104	106	106	122	122	137	137
E [mm] Bore (max.)	32	42	42	55	55	76	76	103	103	103	136	136	190	190	192,7	240
F [mm] Diameter pitch circle fixing screw	85	85	104,8	104,8	133,4	133,4	171,4	133,4	171,4	235	171,4	235	235	330,2	235	330,2
H [mm] Length inside and outside jaw	52	61	61	69	69	90	90	130	130	130	130	130	190	190	190	190
J [mm] Height jaw	22,5	26	26	32,5	32,5	40	40	46	46	46	43	43	54,5	54,5	54,5	54,5
K [mm] Size chuck key	9	10	10	11	11	12	12	14	14	14	17	17	19	19	19	19
Actuation (torque wrench) [Nm]	80	110	110	140	140	150	150	180	180	180	240	240	260	260	280	280
Clamping force [kN] max., total	31	47	47	55	55	63	63	69	69	69	92	92	100	100	105	105
Speed [min-1], max. perm.	5500	4600	4600	4000	4000	3000	3000	2300	2300	2300	1800	1800	1300	1300	850	850
Item no.	185468	185469	185470	185471	185472	185473	185474	185475	185476	185477	185478	185479	185480	185481	185482	185483